

CLAIM AMENDMENTS

1 1. (Currently amended) A bending press for bending
2 metal plates in the production of pipe, comprising:

3 a press bed formed with a lower die against which a metal
4 plate can be pressed to bend said plate;

5 a bending ram extending over the length of said lower die
6 and formed with an upper die of downwardly convex shape engageable
7 with said plate to press said plate against said lower die under
8 said plate; and

9 an articulation for said upper die, said articulation for
10 said upper die including a pivot having a pivot axis extending
11 parallel to said lower die between said upper die and a foot of
12 said ram and forming a pivot axis for said upper die close to an
13 upper surface of said plate.

2. (Canceled)

1 3. (currently amended) The bending press defined in
2 claim [[2]] 1 wherein said articulation includes a pivot for said
3 ram at an upper end thereof having a pivot axis parallel to said
4 die.

4. (Canceled)

1 5. (currently amended) The bending press defined in
2 claim [[4]] 3, further comprising at least one force-restoring
3 member braced to bias said upper die back into an original position
4 upon displacement of said upper die about said articulation.

1 6. (Original) The bending press defined in claim 5
2 wherein said upper die is articulated on said ram, said force-
3 restoring member including a spring braced between said ram and
4 said upper die.

1 7. (Original) The bending press defined in claim 5
2 wherein said ram is formed with said articulation at an upper end
3 thereof and said force-restoring member is braced across said
4 articulation.

1 8. (Original) The bending press defined in claim 5
2 wherein said force-restoring member includes a pair of springs.

1 9. (Original) The bending press defined in claim 1
2 wherein said ram comprises a generally upright plate of
3 substantially uniform wall thickness over its height.

10. Canceled

1 11. (Original) A method of bending a metal plate in the
2 formation of large diameter pipe comprising the steps of repeatedly

3 pressing a metal plate by an upper die at the bottom of a ram
4 driven by a press head from above against a lower die on a press
5 bed and in which the upper and lower die extend over the length of
6 the plate to bend the plate;

7 repeating the bending step until a desired shape is
8 imparted to said plate; and

9 articulating the upper die to enable it to adjust
10 articulating to a contour of said plate during each bending thereof
11 thereby limiting bending stress upon said ram.

1 12. (Original) A method of operating a bending press
2 for the bending of steel plate for the production of large diameter
3 pipe, which comprises the steps of:

4 placing a steel plate on a lower die on a bed of a
5 bending press in which said lower die comprises a pair of supports
6 enabling said plate to be bent between them;

7 pressing an upper die against said plate from above at
8 the bottom of a sword-shaped ram driven by a head of the press
9 downwardly to bend said plate; and

10 articulating said upper die during the bending of said
11 plate so as to minimize a bending moment on said ram.